

Work Order ID 60546

Wednesday, July 14, 2010 8:19:42 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 7/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *10-7-15*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. & Stamp
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Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: *109213* 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

SAD 10-07-13

(2) Cpl 10-07-21

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

(2) 10.07.21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81060121		(x2)			
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAD 10-07-21		(2)			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/07/21 MF 10-7-21

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Picklist Print

Wednesday, July 14, 2010 8:19:46 AM

Page 1

Work Order ID: 60546



Parent Item: D4035-041



Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3 Manufactured No

100

Each

16.0000

1

2



Spacer Bushing



Pl 10.07.21

Location

Loc Qty

Loc Code

WA 16

58406 1

58974 1

59980 14

M304TS0.750W.049 Purchased No

100

f

234.2118

1.75

3.684211



304 SQ Tube .75x.75x.049W



SAD 10-07-13

Location

Loc Qty

Loc Code

MAT 44.73396794

113763 0

114323 23.9557189

114677 14.34201

114835 6.436239

MAT017 3.68448E-05

114298 3.6845E-05

WA 189.4778

114992 189.4778

3.6842

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NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT

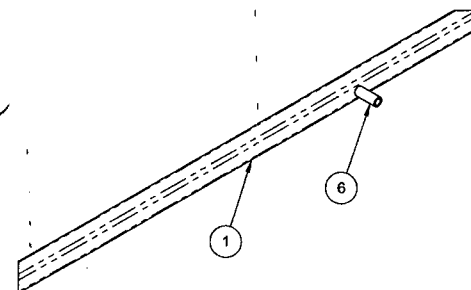
WITHOUT NOTICE

WORK ORDER

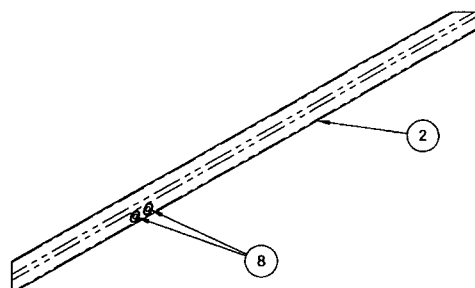
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BS10-715

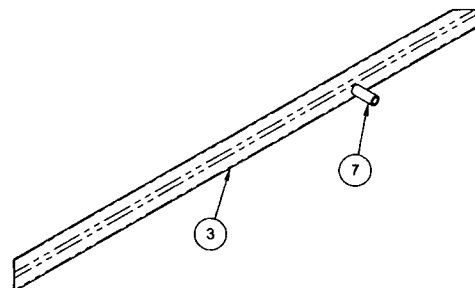
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



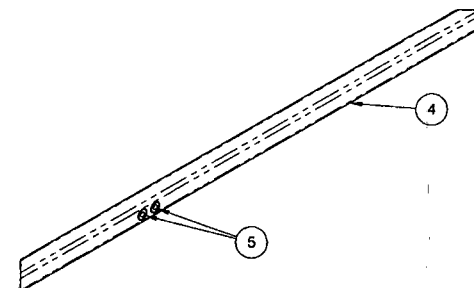
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4035 TITLE BASKET LID RIB ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		REV. A	
DRAWN	JPH			SHEET 1 OF 5	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.					
DATE	10.03.04				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

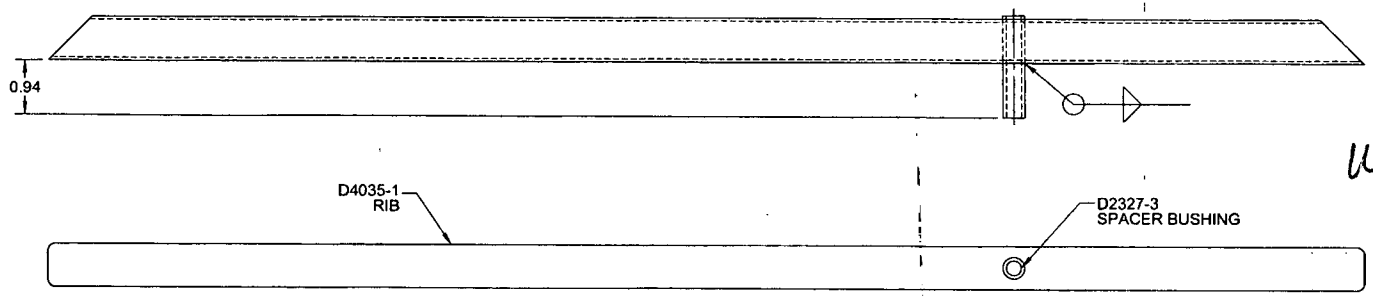
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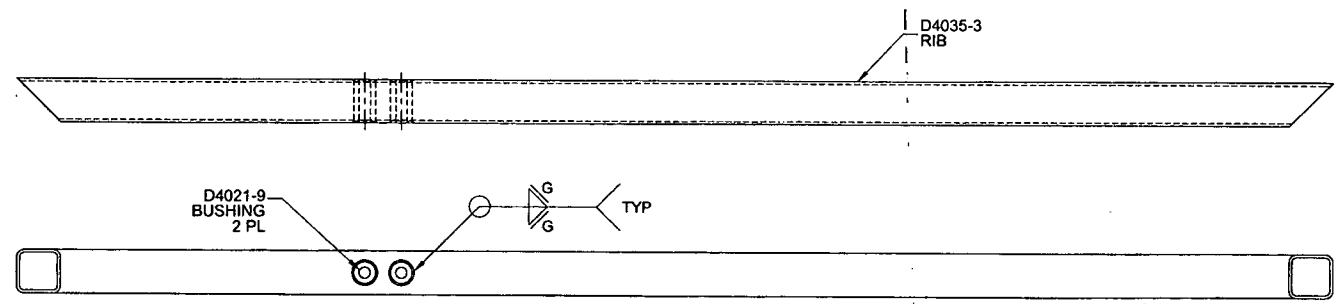
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4035-041 BASKET LID RIB ASSY, FWD







D4035-043 BASKET LID RIB ASSY, AFT

W/O 60546

RELEASED
2010-03-12
W/D

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.83 lbs
 8) WELDING: PER DART QSI 004

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

TYP





D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

w/o 60546

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

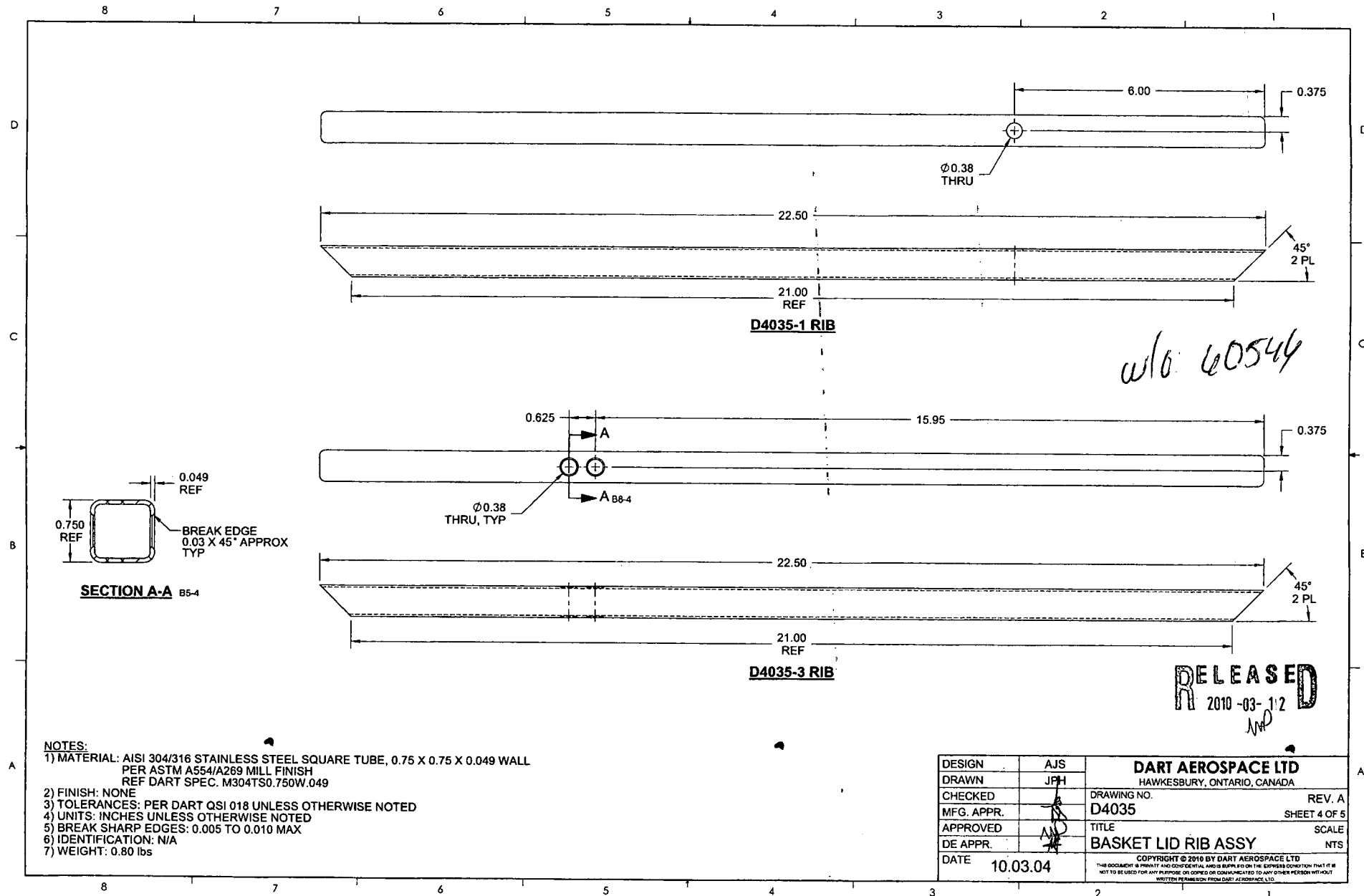
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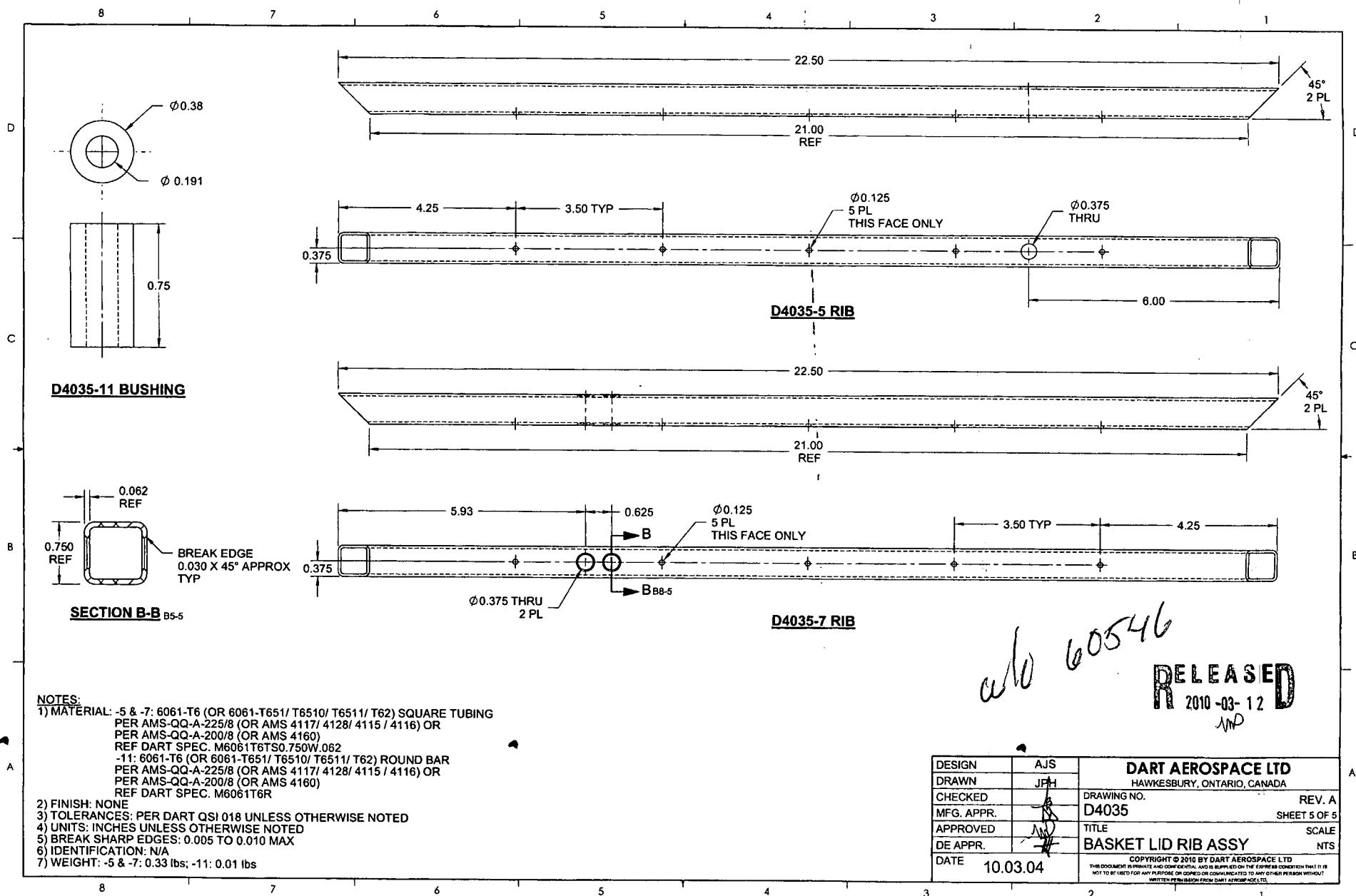
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